

Work Order ID 138262

138262

Page 1

Tuesday, October 27, 2015 11:06:40 AM

Item ID: D4703-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lock Pin Base

Start Date: 10/26/2015 Start Qty: 400 *4*

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 400 *4*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLS Date: OCT 28 2015 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4703	A

100 Cut blanks as per folio 0.00

100

Bandsaw Memo 0.00
Jeaspa Bandsaw CUT BLANK AT 2.6"

12 0 215-12-15

110 0.01

110

HAAS 1 Memo 0.02
HAAS CNC vertical machine #1 MACHINE AS PER DWG & FOLIO FB132
FOLIO REV: AA
DWG REV: A

12 0 215-12-22

DEBURR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

Tuesday, October 27, 2015 11:06:40 AM

Item ID: D4703-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lock Pin Base
 Start Date: 10/26/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/26/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						12	0		SL151221
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130						12	0		DAS 14 9-89
QC	Memo	0.00							151221
Quality Control									
132	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
132						CL		JAN 04 2016	12
Outsource4	Memo	12.00							
Outsource process - Anodize	ISSUE P/O: 30861 MATERIAL CERTS IS REQUIRED								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY																																																																																																																											
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
134	Receive & Inspect for Damage & Mat'l Certs	0.00							
134									
Packaging	Memo	0.00							
Packaging									
136	QC3- Inspect Part Finish	0.00							
136									
QC	Memo	0.00							
Quality Control									
137		0.00							
137									
Small Fab	Memo	0.01							
Small Fab	INSERT HELICOIL								

12X SP 16-1-8

12 FF

DAS 38 9-89

JAN 08 2016

JAN 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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DQA: _____ Date: _____



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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Tuesday, October 27, 2015 11:06:40 AM

Page 1

Work Order ID: 138262

138262

Parent Item: D4703-043

D4703-043

Parent Item Name: Lock Pin Base

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-09-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.00 0		Purchased		No			f	17.2100		0.926316			

M6061T6B0 750X01 000

6061-T6 Bar .750 x 1.00

**

SL 15-12-15

Location

Loc Qty

Loc Code

MAT

17.21

m131392

5.21

m132320

12

Each

53.0000

**

9.65

MS21209-F415

Purchased

No

MS21209-F415

Heli-Coil

Location

Loc Qty

Loc Code

ST299

53

M131139

2

M132226

51

133640

12

sf

DQA: _____ Date: _____



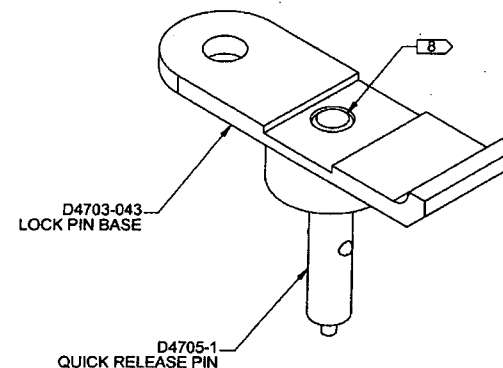
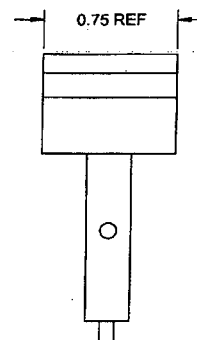
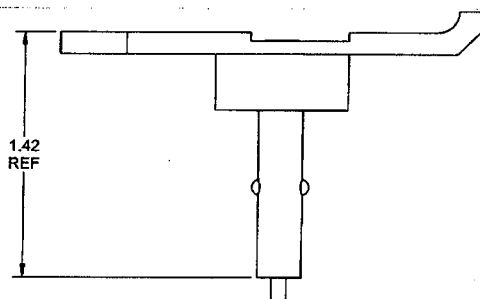
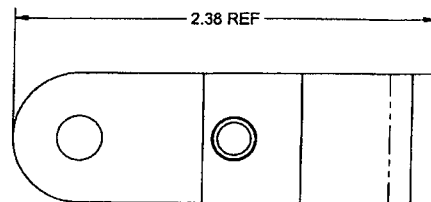
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QA Closed: _____ Date: _____

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OTHER : _____																																																															

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4703-041	LOCK PIN ASSY
1	1	D4705-1	QUICK RELEASE PIN
2	1	D4703-043	LOCK PIN BASE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 138-262 MJS
15-10-28

RELEASED
2012-10-12

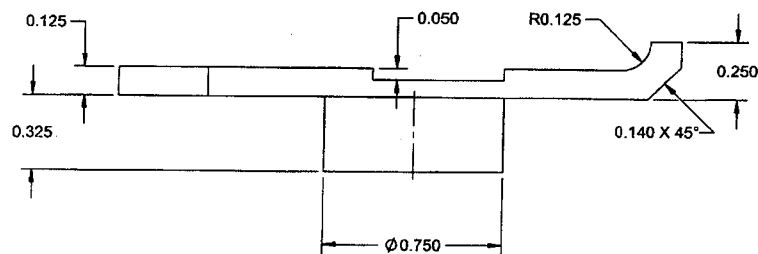
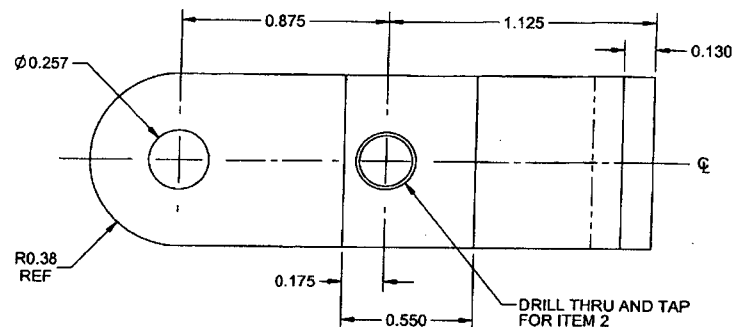
D4703-041 LOCK PIN ASSY

NOTES:

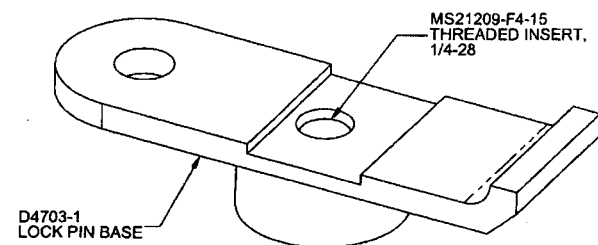
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4703-041" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) APPLY LOCTITE 262 TO D4703-043 THREADS PRIOR TO FASTENING D4705-1

A	NEW ISSUE	RP	12.09.19	
REV.	DESCRIPTION		BY DATE	
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA		
DRAWN	RP			
CHECKED	<i>A.P.</i>		DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>		D4703	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>		TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LOCK PIN ASSY	NTS	
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

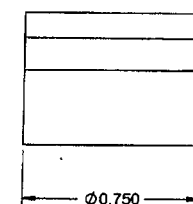
ITEM	QTY.	P/N	DESCRIPTION
	X	D4703-043	LOCK PIN BASE
1	1	D4703-1	LOCK PIN BASE
2	1	MS21209-F4-15	THREADED INSERT, 1/4-28



D4703-1 LOCK PIN BASE



D4703-043 LOCK PIN BASE



RELEASED
2012-10-12

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	RP	KENT, WA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4703	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LOCK PIN ASSY	NTS
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30861

Purchase Order Date 1/4/2016

PO Print Date 1/7/2016

Page Number 1 of 3

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	134704	D5155-043 CO-PILOT REV. B	1/8/2016 Yes 1/8/2016		4.00	\$5.75	\$23.00
		FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE III CLASS 2					
		RUSH ORDER					
						Line Total:	\$23.00
2	138262	D4703-043 LOCK PIN REV. A	1/8/2016 Yes 1/8/2016		12.00	\$2.70	\$32.40
		FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE III CLASS 2					
		RUSH ORDER					
						Line Total:	\$32.40

Note:

1/7/2016



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 64068

Date: 08-Jan-16

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
4 ea	Part: D5155-043 CO-PILOT BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20160003	Rev: B	PO: PO30861 Line:
12 ea	Part: D4703-043 LOCK PIN HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20160007	Rev: A	PO: PO30861 Line:
24 ea	Part: 646.3715 STRUT DOUBLER HARD ANODIZE BLACK AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20160008	Rev: A	PO: PO30861 Line:
4 ea	Part: D5356-043 SUPPORT ASSY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20160009	Rev: PA4	PO: PO30861 Line:
2 ea	Part: D5354-043 SUPPORT ASSY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20160010	Rev: PA7	PO: PO30861 Line:
6 ea	Part: D4822-2 UPPER DEFLECTOR, RH	Rev:	



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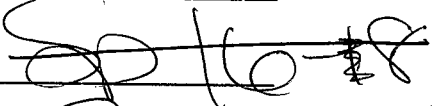
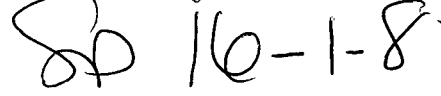
DART AEROSPACE LTD
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HAWKESBURY, ON K6A 1K7
Canada

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Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20160011 PO: PO30861 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>8/1/16</u> CERTIFIED SIGNATURE: <u></u> RECEIVER SIGNATURE: <u></u> <u></u>			